

Work Order ID 143835

March 23, 2016 11:52:59 AM

143835

Page 1

Item ID: D206-836-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Antenna Mount 206L Aft
 Start Date: 4/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/13/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 30160322 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-2	A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D206-836-013 CH001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLS APR 13 2016

3 DAS 28 9-89

APR 13 2016

3 APR 13 2016

DAS 27 9-89

3 DAS 28 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: D206-836-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Antenna Mount 206L Aft

Stop ***NS2***Start Date: 4/7/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/13/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-836-013

Location: _____

PPP Rev: _____

1X 506

2X Fg124

3x

DAS
28
9-89

APR 13 2016

140

QC21 - Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MC

APR 13 2016

MC

APR 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Page 1

Work Order ID: 143835

143835

Parent Item: D206-836-013

D206-836-013

Parent Item Name: Crosstube Antenna Mount 206L Aft

Start Date: 4/7/2016

Required Date: 4/13/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.07.18 AS PER ECN13-561 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4853-7		Manufactured	No				Each	9.0000		13			DAS 6 9-89
---------	--	--------------	----	--	--	--	------	--------	--	----	--	--	------------------

D4853-7

Top Bracket (Replaces P/N G13013-9)

DAS
28
9-89

Location

Loc Qty

Loc Code

ST519

9

104864

1

109078

8

D4854-7		Manufactured	No				Each	14.0000		13			DAS 6 9-89
---------	--	--------------	----	--	--	--	------	---------	--	----	--	--	------------------

D4854-7

Lower Bracket (Replaces P/N G13013-10)

DAS
28
9-89

Location

Loc Qty

Loc Code

st526

14

104867

4

109083

10

D4855-1		Manufactured	No				Each	0.0000		13			DAS 6 9-89
---------	--	--------------	----	--	--	--	------	--------	--	----	--	--	------------------

D4855-1

Antenna Bracket (Replaces P/N G13013-28)

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

22

135594

22

ST410

24

142155

24

D2732-030		Manufactured	No				Each	46.0000		26			DAS 6 9-89
-----------	--	--------------	----	--	--	--	------	---------	--	----	--	--	------------------

D2732-030

Rubber Cushion - 3"

DAS
28
9-89

APR 13 2016

DAS
6
9-89

Picklist Print

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Work Order ID: 143835

143835

Parent Item: D206-836-013

D206-836-013

Parent Item Name: Crosstube Antenna Mount 206L Aft

Start Date: 4/7/2016

Required Date: 4/13/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-16A

Purchased

No

Each

331.0000

26

AN4-16A

Bolt

**

DAS
27
6 9-89
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

100

M134502

100

ST343

226

M128813

12

M134055

14

M134134

200

DAS
28
9-89

AN4-11A

Purchased

No

Each

82.0000

26

AN4-11A

BOLT

**

DAS
27
6 9-89
9-89

Location

Loc Qty

Loc Code

FG

20

120731

20

ST344

62

M128769

8

M133234

54

DAS
28
9-89

NAS1149D0432J

Purchased

No

Each

370.0000

824

NAS1149D0432J

WASHER

**

DAS
27
6 9-89
9-89

Location

Loc Qty

Loc Code

GA

213

m131026

213

ST269

157

m131026

157

DAS
28
9-89

22

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 143835

143835

Parent Item: D206-836-013

D206-836-013

Parent Item Name: Crosstube Antenna Mount 206L Aft

Start Date: 4/7/2016

Required Date: 4/13/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

Each

2,530.000

412

**

DAS

6

9-89 DAS

27

9-89

3 ***MS21042L 4***

Locknut

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

426

m133769

426

OVER007

1500

m134502

1500

ST303

470

m134055

470

ST305

97

m130922

97

DAS
28
9-89

APR 13 2016

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
1				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT

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Revision: A
Date: 13.05.15